



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3065-1

Job Sheet 178557



Part No: D3065-1

Job Qty: 40 ea ^{DAG}21
9-89

Part Name: Step Spacer



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/1/18

Job Tracking No:

Due Date: 6/22/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP: C 02.11.01 Incorporated D3066-1 IPP KJ/RF IPP:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	40 Ea		6/22/18	0.00	0.00	Start Up Waterjet		9/8/06/09
100	Waterjet	40 pcs		6/22/18	0.00	1.41	Waterjet1		9/8/06/09
120	QC	40 pcs		6/22/18	0.00	0.00	QC8		9/8/06/09
132	Brake NC	40 pcs		6/22/18	0.02	1.07	Brake NC 2		9/8/06/09
150	QC	40 pcs		6/22/18	0.00	0.00	QC5		9/8/06/09
160	HandFinish	40 pcs		6/22/18	0.00	0.58	HandFinish1		9/8/06/09
161	QC	40 pcs		6/22/18	0.00	0.00	QC7-1		9/8/06/09
180	Packaging	40 pcs		6/22/18	0.00	0.00	Packaging3-1		9/8/06/09
190	QC21-SA	40 Ea		6/22/18	0.00	0.00	QC21		9/8/06/09

Part Op 100 - 1-Cut as per Dwg D3065
Descriptions: 180 - LOCATION : GA

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.040	2024-T3 .040 Sheet	4.9520 sf (.1238 ea) 4.45	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M2024T3S.040	5	171	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Step Spacer	0.250inches ± 0.010	0.260 0.240	0.251	
2	Step Spacer	2.093inches ± 0.010	2.103 2.083	2.095	
3	Step Spacer	3.936inches ± 0.010	3.946 3.926	3.940	
4	Step Spacer	4.186inches ± 0.010	4.196 4.176	4.190	
5	Step Spacer	0.587inches ± 0.010	0.597 0.577	0.590	
6	Step Spacer	0.128inches	0.133	0.129	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Cross tube ☐ Small Fab ☐ Finishing ☐		Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Repack ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		DART AEROSPACE Container No: S079486 Part: D3065-1 Job No: 178557 Serial No/Batch: S079486 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: _____ Date: 06/10/18							
Description Work Order Dev: _____											
Root Cause <table style="width:100%;"> <tr> <td style="width:50%;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width:50%;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> </tr> </table>		Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	<table style="width:100%;"> <tr> <td style="width:50%;"> Pressure/ Bending Centre Nc Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Wave/Twist in Tube Marks/Chatter </td> <td style="width:50%;"> Broken/Damage/Defect Inspection Incomplete/Unqualified Contamination Countersink Cut Too Short Instructions Incomplete/Unclear Drill Holes </td> </tr> </table>		Pressure/ Bending Centre Nc Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Wave/Twist in Tube Marks/Chatter	Broken/Damage/Defect Inspection Incomplete/Unqualified Contamination Countersink Cut Too Short Instructions Incomplete/Unclear Drill Holes	<table style="width:100%;"> <tr> <td style="width:50%;"> Grain Weld Wrong Stock Pulled Out of Sequence Off-set Mislabeled Fit/Function Misaligned/off center </td> <td style="width:50%;"> tioned Wrong Side Dimensions Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Drawing Finish Misread Turning Sequence </td> </tr> </table>		Grain Weld Wrong Stock Pulled Out of Sequence Off-set Mislabeled Fit/Function Misaligned/off center	tioned Wrong Side Dimensions Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Drawing Finish Misread Turning Sequence
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OTHER : _____											

			+ 0.005 - 0.001	0.127	
7	Step Spacer	0.125inches	± 0.010	0.135 0.115	0,125
8	Step Spacer	3.465inches	± 0.010	3.475 3.455	3,463
9	Step Spacer	1.250inches	+ 0.012 - 0.001	1.262 1.249	1,252
10	Step Spacer	0.368inches	± 0.010	0.378 0.358	0,370
11	Step Spacer	0.871inches	± 0.005	0.876 0.866	0,870
12	Step Spacer	0.040inches	± 0.010	0.050 0.030	0,040

Plex 6/1/18 1:55 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
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